

Date: Thursday, 13/11/2008 10:06:55 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 43378		
Estimate Number	: 11606		
P.O. Number	:	Part Number	: D2930
This Issue	: 13/11/2008 S.O. No. :	Drawing Number	: D2930 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 43378	Material	:
Written By	: <u>08-11-13</u>	Due Date	: 20/11/2008 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est A 04.08.05 New issue KJ/JLM est B 07.08.07 ECN930 EC verified by:JLM Est Rev:C 08-11-13 Now on Waterjet JLN Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S100	6061-T6 .100 Sheet
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MAY NOT pull ED



Comment: Qty.: 0.0446 sf(s)/Unit Total : 0.4463 sf(s)

M6061-T6 .100 SHEET

Batch: 108595

B 8-11-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2930

Dwg Rev: B

B 8-11-20

Prog Rev: B

2-Deburr if necessary

B 8-11-20

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-11-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50814/21 (476) counter

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(20X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/11/22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 43378

Part Number: D2930

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 08 11 22

(20)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

QC5

INSPECT WORK TO CURRENT STEP



n/a

Solut 24



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST53

SS 08/11/24 K20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/27 H

Comment: FINAL INSPECTION/W/O RELEASE

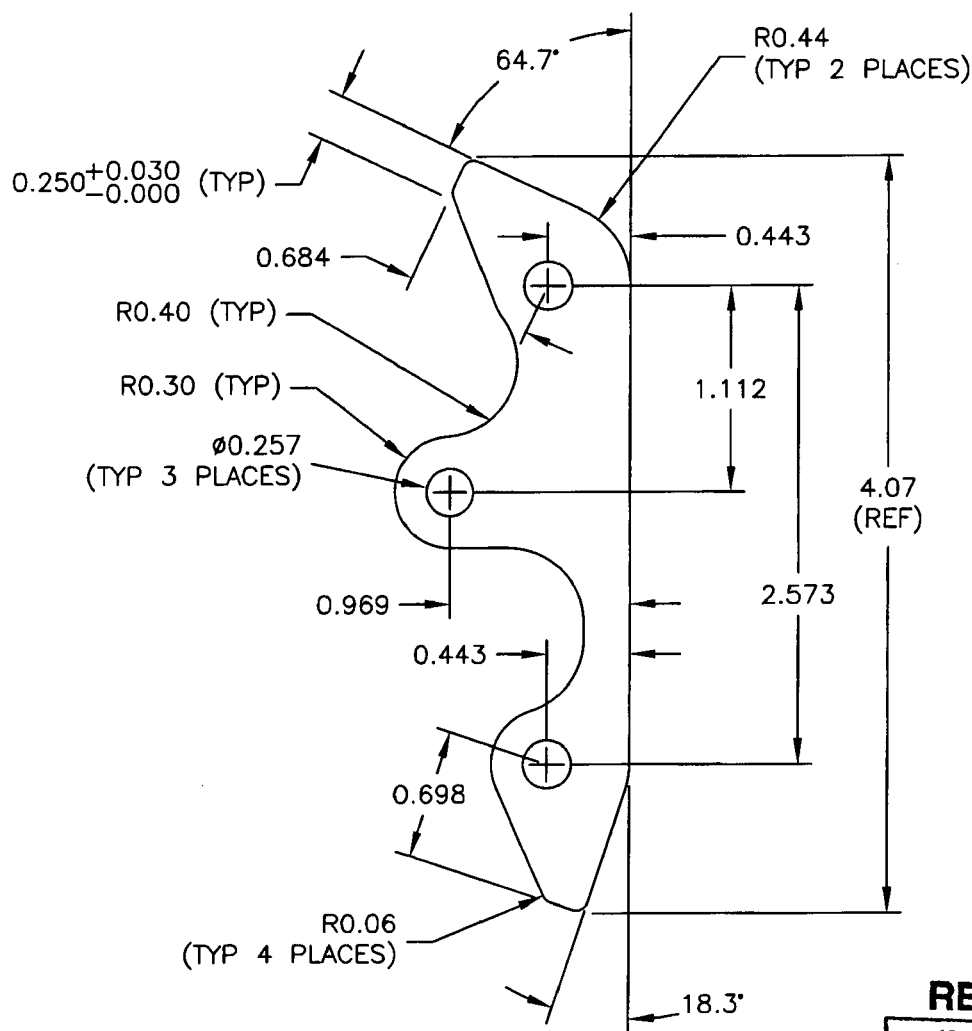
Job Completion



2008.11.27

DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2930	REV. B SHEET 1 OF 1
DATE 07.06.26		TITLE SPACER	SCALE 1:1
A	99.10.27	NEW ISSUE	
B	07.06.26	ADD 6061-T6; UPDATE NOTES	

**RELEASED**07.07.31 *H***NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.100 THICK, PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.100) OR ALUMINUM 5052-H32/H34 SHEET, 0.100 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43378*

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